

December-17-14 2:00:28 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 12/29/14 **Start Qty:** 800 *70* ***g***

Cust Item ID:

Required Date: 12/29/14 **Req'd Qty:** ~~8.00~~ ***O***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-12-19 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4727	REV A

110

0.00

110

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

Machine D4727-1 as per folio FB

FOLIO REV: 1A

DWG REV: A

Deburr

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS

40

9-89

15/01/10

DAS

40

9-20

15/01/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Work Order ID 127908

December-17-14 2:00:28 PM

127908

Page 3

Item ID: D4727-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Barrel
 Start Date: 12/29/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/29/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>S-125</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

(251)

DAS
46
9-89

JAN 12 2015

MLJ 15-01-12

1278-112

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

December-17-14 2:00:28 PM

Page 1

Work Order ID: 127908

127908

Parent Item: D4727-041

D4727-041

Parent Item Name: Barrel

Start Date: 12/29/14

Required Date: 12/29/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			110	f	44.5830	0.054	0.454737			
M303R0 500									**			15/01/10	DAS 40 9-89
303 Round Bar 0.500"													

Location	Loc Qty	Loc Code
MAT028	44.583	
P M130451	44.583	

MS21209F1-15	Purchased	No				140	Each	280.0000	1				
--------------	-----------	----	--	--	--	-----	------	----------	---	--	--	--	--

MS21209F1-15

HELI COIL

Location	Loc Qty	Loc Code
CA	203	
m129682	203	
ST299	77	
m130505	50	
m130626	27	

1.75

25

15/01/12

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

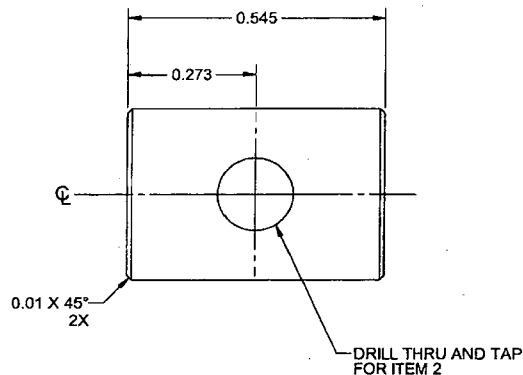
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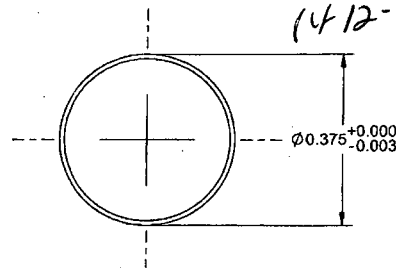
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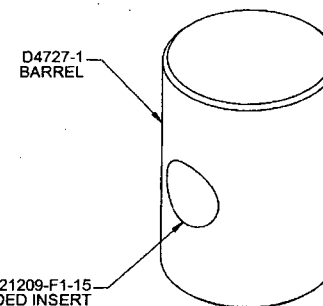
ITEM	QTY	P/N	DESCRIPTION
	X	D4727-041	BARREL
1	1	D4727-1	BARREL
2	1	MS21209-F1-15	THREADED INSERT, #10-32 UNC



D4727-1 BARREL



TOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
NO AMENDMENT
NOTICE
WORK ORDER
127908
ML5
1412-19



D4727-041 BARREL

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303R1.000 OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R1.000
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

REV.	NEW ISSUE	DESCRIPTION	RP	12.09.19
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA	BY	DATE
DRAWN	RP			
CHECKED	AC	DRAWING NO. D4727		REV. A
MFG. APPR.				SHEET 1 OF 1
APPROVED		TITLE BARREL		SCALE
DE APPR.				NTS
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		